

Work Order ID 134921-1

Wednesday, July 22, 2015 4:16:22 PM

134921

Page 1

Item ID: D3694-1

Revision ID:

Item Name: Mounting Plate

Start Date: 7/22/15

Start Qty: 1.00

Required Date: 7/22/15

Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: JUL 23 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3694	Rev C

100 0.00

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank 7.150" long

0.00

7 ϕ 216-15

DAS
45
9-89
2016-01-08

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA731 Rev: AA & Dwg D3694 Rev: C 2-Tap 10-32 heli-coil holes Manually 2-Deburr per dwg D3694

0.00

1 ϕ

DAS
45
9-89
2016-01-07

120

0.00

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

1 ϕ

DAS
45
9-89
2016-01-07

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date: _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Work Order ID 134921

Wednesday, July 22, 2015 4:16:22 PM

134921

Page 2

Item ID: D3694-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Mounting Plate

Stop

NS2

Start Date: 7/22/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/22/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS
44
9-89

16/01/08

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

As of 16/01/11

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

*****Mask all in surface as per Dwg

D3694*****START TIME:

0.00 OVEN TEMPERATURE: 320° FINISH
TIME: 7:20

1 of 16-01-11

DAS
34
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>					Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition			Completed By																	
3AG 5A 10/10/10					Lead hand / Supervisor Approval Verification																	
					QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																				
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OTHER : _____																						

Work Order ID 134921

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134921

Page 3

Item ID: D3694-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Plate
 Start Date: 7/22/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/22/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				1			DAS 38 9-89
160									
QC	Memo	0.00							JAN 12 2016
Quality Control									
170	Identify as per dwg & Stock Location <u>51510</u>	0.00				1			
170									
Packaging	Memo	0.00							JAN 13 2016
Packaging									DAS 6 8-89
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							JAN 13 2016
Quality Control									MCS

JAN 13 2016

MCS

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
10-5-2018 10-5-2018 10-5-2018				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Picklist Print

Wednesday, July 22, 2015 4:16:21 PM

Page 1

Work Order ID: 134921

134921

Parent Item: D3694-1

D3694-1

Parent Item Name: Mounting Plate

Start Date: 7/22/15

Required Date: 7/22/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 09-01-13 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.000X06.00
0

Purchased

No

f

43.6790

~~9.630315~~

M6061T6B1 000X06 000

**

6061T6 BAR 1.00 X 6.00

Location

MAT003

Loc Qty

43.679

m125771 x3

2.4

m127797

2.7

m129530

2.15

m129639 x3 + x1

18.2

m130013

18.229

1.8

22 + 9.604 ft

4.604 ft

DAS
45 2016-01-08
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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OTHER : _____																					

DART AEROSPACE LTD		Work Order: 134921
Description: Keyway		Part Number: D3694-1
Inspection Dwg: D3694	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	0.205	✓		caliper	Steel
0.673 deep	+/-0.010	0.669	✓		"	"
Ø0.257	+0.006/-0.001	0.259	✓		"	"
0.200 deep	+/-0.010	0.199	✓		"	"
6.75	+/-0.030	6.747	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
4.000	+/-0.010	4.000	✓		"	"
1.000 pitch	+/-0.010	1.000	✓		"	"
0.375	+/-0.010	0.376	✓		"	"
4.114	+/-0.010	4.113	✓		HV	31006
1.375	+/-0.010	1.373	✓		caliper	Steel
2.000	+/-0.010	1.998	✓		"	"
2.500	+/-0.010	2.499	✓		"	"
Ø0.204	+0.005/-0.001	0.206	✓		"	"
0.500	+/-0.010	0.499	✓		"	"
4.602	+/-0.010	4.604	✓		"	"
1.000	+0.010/-0.000	1.004	✓		cal + pin	Steel + Snap
0.13 x 45°	+/-0.030 x 0.5°	0.130 x 45°	✓		depth G + Angle	Steel + Snap
R0.13	+/-0.030	0.125	✓		rad G	Snap
0.88	+/-0.030	0.885	✓		micro V-1	Steel
0.125	+0.030/-0.000	0.142	✓		"	"
5.60	+/-0.030	5.60	✓		caliper	Steel
3.60	+/-0.030	3.603	✓		"	"
2.020	+0.050/-0.000	2.027	✓		"	"
0.505	+0.000/-0.005	0.503	✓		"	"
1.0	+/-0.030	0.999	✓		HV	31006
1.791	+/-0.010	1.785	✓		"	"
2.301	+/-0.010	2.297	✓		"	"

DAS
45
9-89

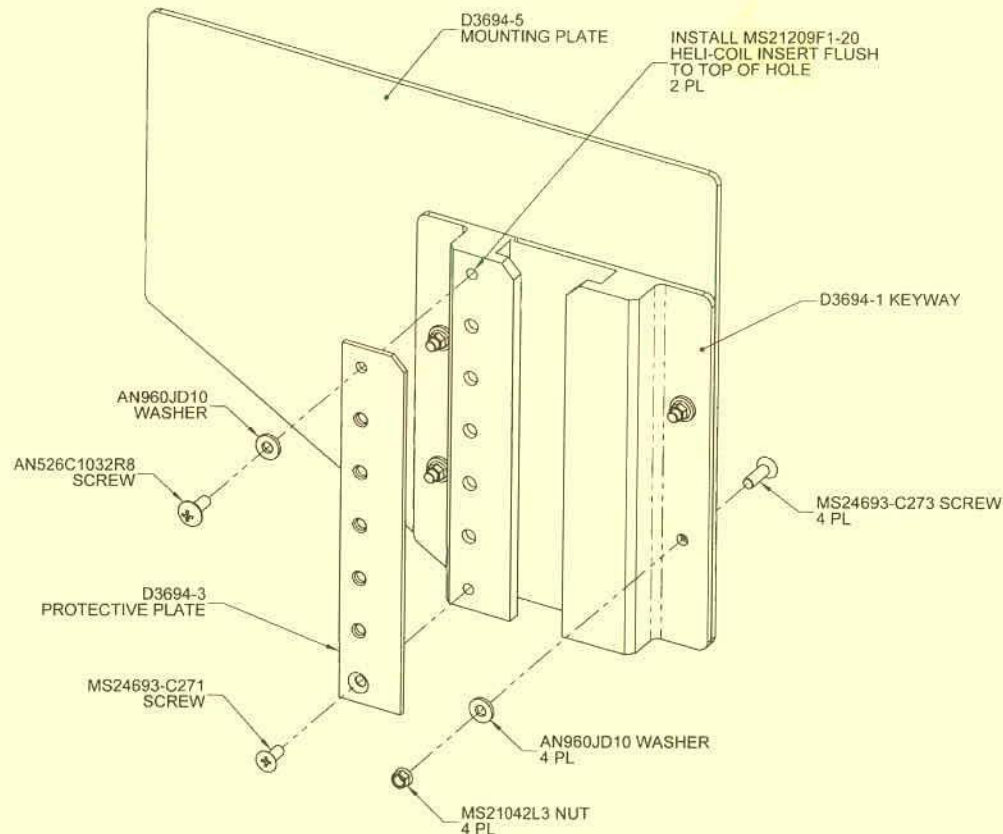
DAS
44
9-89

Measured by:	DAS 45 9-89
Date:	2016-01-07

Audited by:	DAS 44 9-89
Date:	16/01/08

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	



D3694-041 MOUNTING PLATE ASSY

D3694-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

134921 MJS
15-07-23

RELEASED
09/05/15

C	REDESIGNED ITEM 11; REVISED ITEM 12. DIM. Ø0.204 WAS Ø0.234 (ZN D6-3). ADDED ITEM 13; UPDATED BOM TO CURRENT STANDARDS (ZN D3-1). REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT	MB	08.11.03
B	QTY 1 MS24693-C271 SCREW WAS QTY. 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.18 WAS 1.15 (ZN C7-3). CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3). REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3694** REV. C
SHEET 1 OF 4
TITLE **MOUNTING PLATE ASSY** SCALE NTS

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Ø0.201 X 0.673 DP
TAP HOLE FOR #10-32 UNF
RED HELI-COIL INSERT
2 PL

MASK ALL HOLES
PRIOR TO PAINTING

Ø0.257 X 0.200 DP
5 PL

0.25 X 45°
CHAMFER
2 PL

0.500
R0.188
TYP

Ø0.204 THRU
4 PL

6.75 6.000 4.000
1.000 PITCH
TYP

0.375

4.114

2.500

2.000

1.375

0.13 X 45°
2 PL

1.000^{+0.010}
-0.000

R0.13
2 PL

0.88

0.125^{+0.030}
-0.000

2.301

1.791

1.00

0.505^{+0.000}
-0.005
2 PL

MASK KEYWAY
PRIOR TO PAINTING

2.020^{+0.050}
-0.000

3.60

5.60

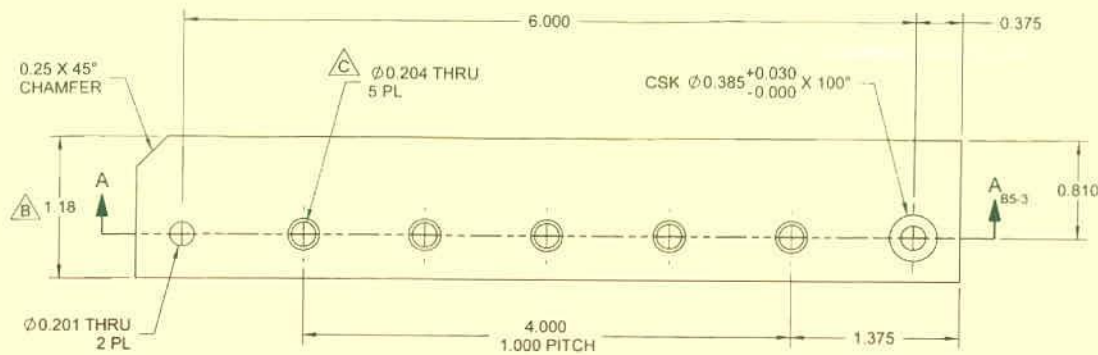
D3694-1 KEYWAY

D3694-1 NOTES:

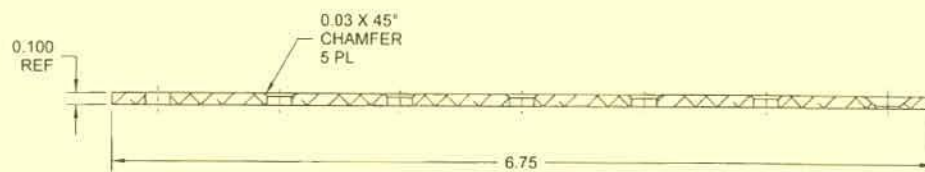
- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

RELEASED
09/06/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3694	REV. C
MFG. APPR			SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR		MOUNTING PLATE ASSY	NTS
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D3694-3 PROTECTIVE PLATE



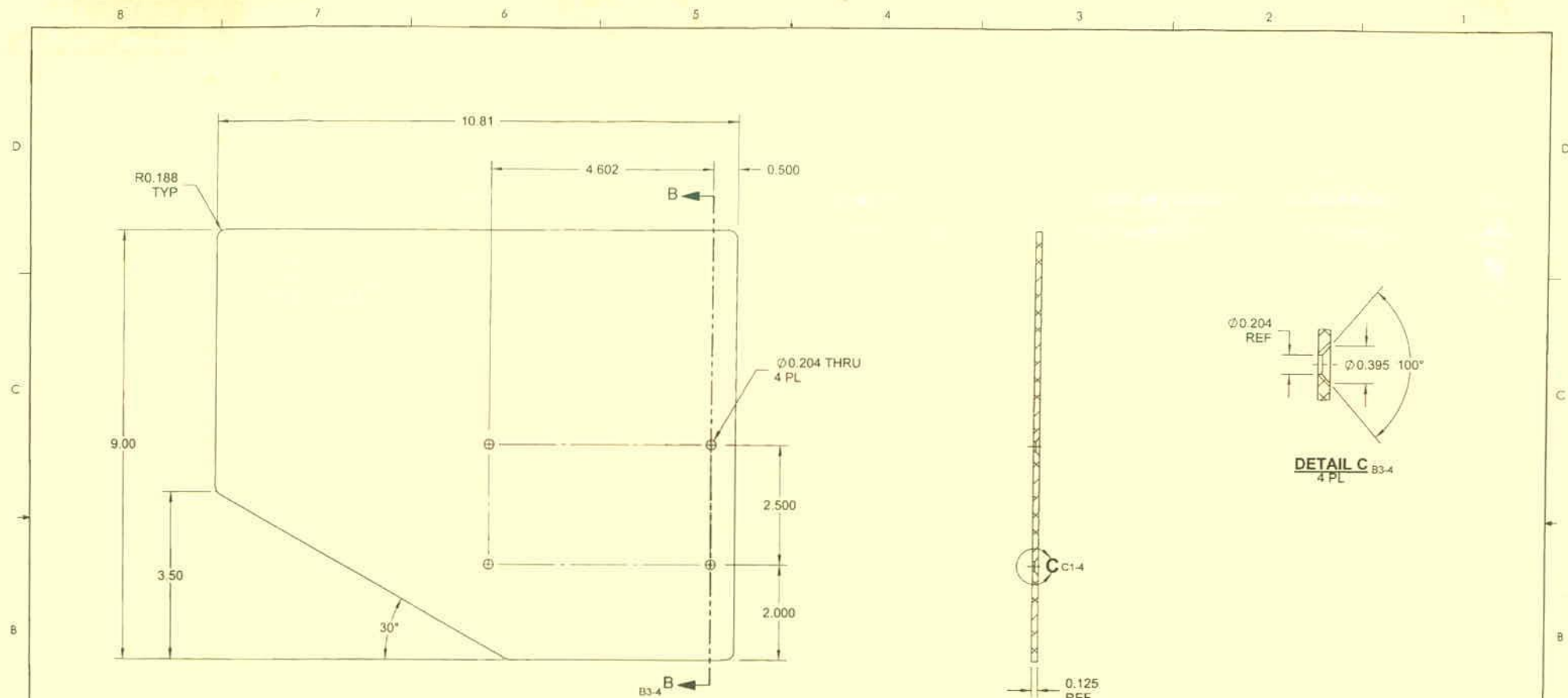
SECTION A-A_{C3-3}

D3694-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),
PER PER AMS 5513 OR AMS 5524
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

RELEASED
07/02/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3694	REV. C
MFG APPR			SHEET 3 OF 4
APPROVED		TITLE MOUNTING PLATE ASSY	SCALE
DE APPR			NTS
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D3694-5 MOUNTING PLATE

SECTION B-B B5-4

D3694-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

RELEASED
69/05/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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